

I claim:

**1.**

1           In combination, a single ply membrane roofing system secured  
2 to a roof deck; said system comprising a first flexible membrane with a  
3 longitudinally extending edge secured to said roof deck by transversely  
4 spaced fasteners, said membrane system having a second flexible  
5 membrane with an edge portion overlapping said first membrane edge and  
6 weld bonded to said first membrane via a continuous weld bond along the  
7 edge of said second membrane such that said first membrane edge projects  
8 forwardly from said bond to define a fastening projection for said fasteners  
9 extending forwardly from said weld bond, and having the improvement  
10 comprising:

11           a.     an adhesive coating over said fastening projection and  
12 fasteners, extending essentially from said weld bond forwardly to provide a  
13 continuous adhesive coating over said first membrane projection and  
14 fasteners providing a substantially monolithic bond comprising said weld bond  
15 and adhesive coating.

**2.**

1           The combination of claim 1 wherein said adhesive coating  
2 extends down the front edge of said first membrane to provide a coating  
3 stepping portion extending down past the front edge of said first membrane to

4 the level of said deck between said first membrane and the underside of said  
5 second membrane.

**3.**

1 The combination of claim 1 wherein said adhesive coating  
2 extends forwardly of said front edge of said first membrane for a short  
3 distance between said second membrane and deck.

**4.**

1 A method of securing a single ply membrane roofing system to  
2 a roof deck; said system comprising a first membrane with a longitudinally  
3 extending free edge to be secured to said roof deck by transversely spaced  
4 fasteners, said membrane system having a second membrane with an edge  
5 portion overlapping said first membrane edge and bonded to said first  
6 membrane via a continuous weld bond along the edge of said second  
7 membrane such that said first membrane edge projects forwardly from said  
8 weld bond to define a fastening projection extending forwardly from said free  
9 edge under said second membrane, comprising:

10 a. with said system applied to said roof deck and  
11 maintaining said second membrane peeled upwardly back from said weld  
12 bond and fastening projection, placing spaced apart fasteners into said deck  
13 to secure said fastening projection of said first membrane to said deck;

14                   b.       with said second membrane in said peeled back position  
15     applying a liquid adhesive over said fastening edge and fasteners from said  
16     weld bond forwardly to provide a continuous adhesive coating on said first  
17     membrane projection and over said fasteners; and

18                   c.       lowering said second membrane to cover and adhere to  
19     said fastening projection and fasteners and provide a substantially continuous  
20     monolithic bond comprised of said weld bond and adhesive coating.

**5.**

1                   The method of claim 4 wherein said adhesive coating flexibly  
2     extends down the front edge of said first membrane to the level of said deck  
3     between the said front edge of said first membrane and the underside of said  
4     second membrane.

**6.**

1                   The method of claim 5 wherein said adhesive coating extends  
2     forwardly of said front edge of said first membrane for a short distance  
3     between said second membrane and deck.

**7.**

1                   A method of constructing a single ply membrane roofing system  
2     applied to a roof deck; said system comprising a first membrane with a  
3     longitudinally extending front free edge to be secured to said roof deck by

4 transversely spaced fasteners, said membrane system having a second  
5 membrane with an edge portion rearwardly overlapping said first membrane  
6 edge and hot air or dielectric bonded to said first membrane via a continuous  
7 weld bond along the rear edge of said second membrane such that said first  
8 membrane edge projects forwardly from said weld bond to define a fastening  
9 projection extending forwardly from said free edge, comprising:

10           a.       with said system applied to said roof deck, maintaining  
11 said second membrane peeled upwardly back from said bond and fastening  
12 projection and placing transversely spaced apart fasteners into said deck to  
13 secure said fastening projection of said first membrane to said deck;

14           b.       with said second membrane in peeled back position  
15 applying a fast drying liquid adhesive over said fastening edge and fasteners  
16 from said bond forwardly and onto only a portion of said roof deck forwardly of  
17 said first membrane to provide a continuous adhesive coating on said first  
18 membrane projection, said fasteners, and a portion of said deck forwardly  
19 adjacent to said fastening projection, while also applying an adhesive coating  
20 to the underside of said membrane to an extent to cover the adhesive coating  
21 applied to said fastening projection and deck; and

22           c.       lowering said second membrane to cover and adhere to  
23 said coating on said fastening projection, fasteners, and deck portion.